



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5350-043
Job Sheet 180048



Part No: D5350-043

Job Qty: 1 ea

Part Name: Aft Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 2 IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP REV:B 16.01.25 rev.a dwg DD VERF:JLM IPP REV:C 16.06.30 DWG REV:B DD VERF:JLM IPP REV:D 17.01.09 DWG REV:c DD VERF:JLM IPP REV:E DWG. REV.D 17/04/11 JFS VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Machining-4		Kt 2018/07/19
100	Bandsaw	4 pcs	7/13/18	7/13/18	0.00	9.30	Bandsaw1		Kt 2018/07/19
110	CNC Vertical Machining	4 pcs	7/13/18	7/13/18	0.42	23.53	HAAS1-2		Kt 2018/07/19
120	QC	4 pcs	7/13/18	7/13/18	0.00	0.00	QC2 Machining-4		Kt 2018/07/19
130	Mill Conv	4 pcs	7/13/18	7/13/18	0.00	23.11	Mill Conv 1		
140	QC	4 pcs	7/13/18	7/13/18	0.00	0.00	QC8		J.C.L. 18-08-23
150	Skidtubes	4 pcs	7/13/18	7/13/18	0.00	1.29	Skidtubes-3		BL DAS
160	QC	4 pcs	7/13/18	7/13/18	0.00	0.00	QC5		SEP 04 2018 68
170	HandFinish	4 pcs	7/13/18	7/13/18	0.00	1.37	HandFinish1		DR 18/08/10/18
180	QC	4 pcs	7/13/18	7/13/18	0.00	0.00	QC7-5		BL 18-9-5
190	Powdercoat	4 pcs	7/13/18	7/13/18	0.00	2.33	Powdercoat1		BL 18-9-5
200	QC	4 pcs	7/13/18	7/13/18	0.00	0.00	QC3		BL 18-9-5
210	Small Fab	4 pcs	7/13/18	7/13/18	0.00	1.38	Small Fab-9		BL 18-9-5
220	QC	4 pcs	7/13/18	7/13/18	0.00	0.00	QC5		BL 18-9-5
230	Packaging	4 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-2		
240	QC21-SA	4 Ea	7/13/18	7/13/18	0.00	0.00	QC21		

M 83893

START: 9:30

OUT: 320°

FINISH: 10:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	22.2800 ft (5.57 ea)	90-Start up Operation	5090372
CBL-1240	Cable	10.84 21.0000 ft (5.42 ea)	210-Small Fab	5032061
CBL-460	Loop Sleeve	20 40 Ea (10 ea)	210-Small Fab	5032061
D5346-3	Bushing	8 40 Ea (4 ea)	210-Small Fab	5108052
D5350-5	Adapter	2 1 Ea (1 ea)	210-Small Fab	5098002
MS17984-C412	Pin, Quick Release	4 1 Ea (2 ea)	210-Small Fab	5090932
MS17984-C418	Quick Release Pin	2 1 pcs (1 ea)	210-Small Fab	5036480
MS17984-C517	Pin, Quick Release	4 1 Ea (2 ea)	210-Small Fab	5036480

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	22	26	0 66.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>D5350-043</u> Part No. <u>1800418</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Machining</td><td>☒</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>						Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☒	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐	Supplier	☐																																																																																																
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Date : <u>18-08-18-09-04</u>		Step #: <u>110</u>		QTY Effective : <u>2</u>			MRB (QSI042) Approval <u>DAS</u> <u>9</u> <u>9-89</u> <u>18-09-04</u>																																																																																																																																
Description Work Order Deviation				Disposition				Completed By																																																																																																																															
<u>CSK Ø.415" x 90° is Ø.530"</u>				<u>Scrap destroy</u>				Lead hand / Supervisor Approval Verification <u>18-09-04</u>																																																																																																																															
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210-Small Fab

CBL-1240	22	295	0
CBL-460	40	273	0
D5346-3	16	3	0
D5350-5	4	3	0
MS17984-C412	8	11	0
MS17984-C418	4	33	0
MS17984-C517	8	46	0

Part Specifications

Specifications could not be found.

Plex 6/28/18 9:42 AM Dart.lajeunesse.marie



Container No: S093585



Part: D5350 - 043

Job No: 180048

Serial No/Batch: S093585

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/19/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .257	+ .003 / - .001	.2588	✓		Pin gauge	
0.65	+/- .030	.655	✓		vernier	
1.90	+/- .030	1.903	✓		vernier	
3.15	+/- .030	3.155	✓		vernier	
0.55	+/- .030	.535	✓		vernier	
.280	+ .015 / - .005	.281	✓			
12.000	+/- .030	11.998	✓		vernier	"12 place"
5.42	+/- .030	5.395	✓		high gauge	
.550	+/- .010	.556	✓		vernier	
.225	+/- .010	.222	✓		vernier	
1.00	+/- .030	1.002	✓		vernier	
0.30	+/- .030	.315	✓		vernier	
0.35	+/- .030	.363	✓		vernier	
2.50	+/- .030	2.500	✓		vernier	
0.70	+/- .020	0.700 .710	✓		vernier	
1.50	+/- .030	1.500	✓		vernier	
2.43	+/- .030	2.428	✓		vernier	
1.60	+/- .030	1.600	✓		vernier	
3.88	+/- .030	3.875	✓		vernier	
0.30	+/- .030	.307	✓		vernier	
0.35	+/- .030	.353	✓		vernier	
0.20	+ .030 / - .010	.197	✓		vernier	
0.40	+/- .030	.397	✓		vernier	
0.45	+/- .030	.447	✓		vernier	
0.55	+/- .030	.543	✓		vernier	
0.65	+/- .030	.640	✓		vernier	
0.30	+/- .030	.299	✓		vernier	
0.30	+/- .030	.298	✓		vernier	
3.00	+/- .030	3.002	✓		vernier	
Ø .375	+ .0004 / - .001	.374	✓		Pin gauge	
Ø .415	+/- .010					

Measured by:	MM	Checked by:	J.C.L.	QC Inspector:	
Date:	2014/07/18	Date:	18-08-23	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

